Work Ord Wednesday, Ma											Page
Item ID: Revision ID:	D500-572-01	1		Accept				s	Setup Sta	1 (3 3 () ()	
Item Name: Start Date: Required Date: Reference:	Bearpaw 5/19/2010 5/26/2010	Start Qty: 2.00 Req'd Qty: 2.00	1		Cust Iten Custome				Sto	'P 	
Approvals:	Process Plan	n:	Date: <u> 10-5-</u>	Tooling: SPC (Y/N):		Date:		R	Run Sta Sto		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	·····	sion Nbr		,			•				
D2435 100 DC Document Control	Rev I	DOCUMENT CONTR	OL bluefile and create labels po	0.00	HG005	10/06 V	<u>. </u>	+9	for	BG K	106/11
160 Packaging Packaging		Pick Kit Memo		0.00 =7 N	nl	15/06	/11				-

170 QC

Quality Control

Memo

QC4- 100% Inspect kits for completeness

0.00

0.00

Ewlock

W/O:			WC	RK ORDER CHANG	ES				c 3
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	4 :	Date:	
	Res	olution:	Dispositio	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	ion B	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 58871

Wednesday, May 19, 2010 3:30:13 PM



Page 2

Item ID:

D500-572-011

Accept

Setup Start



Revision ID:

Item Name: Bearpaw

Start Date: 5/19/2010

Start Qty: 2.00

Required Date: 5/26/2010 Req'd Qty: 2.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:____

Tooling:

Run

Accept

Qty

Start

Reject

Stop



Number Stamp

QC:

Date:

SPC (Y/N):

Date:

Draw

Number

Date:

Plan

Code

Draw

Rev.

Stop



Insp.

Sequence ID/

Work Center ID

180

Packaging

Packaging

Operation Description

Packaging

Set Up/ **Run Hours**

0.00

Memo Identify and pack for shipping as per PPPD500-572-

011 □ Location:

Reject

Qty

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aero	space I	Ltd
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W/O:			W	ORK ORDER CHANG	ES				c 3
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	s No DQ	A:	_ Date: _	
	Re	esolution:					- H.V.	Date: _	
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· Picklist Print												Page 1
Wednesday, May 19	9, 2010 3:30:18 P.	M									•	h
Work Order ID: 58	3871											
	500-572-011											
Parent Item Name:	Bearpaw						S	Start Date: 5	/19/2010	Required	Date: 5/26/20	010
Comments:	IPP Rev:C□04.02 IPP Rev:D 07-03 IPP Rev:E 08-01 IPP Rev:F 08-10	-09 Added Step 2	7 JL	M			;	Start Qty: 2.	.00	Require	d Qty: 2.00	
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AN4-15A FY		Dunchesed	No	113288	170	10	207.000	1.6		- 		
		Purchased	INU		170	Each	307.0000	/ 6				
\mathcal{O}_{Bolt}								{				
				<u>Location</u>	<u>Lo</u>	oc Oty	Loc Code				·	
				ST358 114239	<i></i>	307 26				_		
				114292 114615		181 100			Tlay	- - Ma	l wlo	16/11
AN960JD416 X	X	Purchased	No	114013	170	Each	0.0000	8	108	_ /////		
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		Manufactured	110		170	1	320.4136	8× 1.666			·	•
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W/O:			W	ORK ORDER CHANG	GES					*
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Part No		PAR #:								
	R	esolution:							Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	tion B	Sign &	Verific		Approval	Approval
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· Picklist Print

Wednesday, May 19, 2010 3:30:18 PM

Page 2

Work Order ID: 58871

Parent Item:

D500-572-011

Parent Item Name:

Bearpaw

IPP Rev:F

Comments:

IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□ Was K10007

IPP Rev:D 07-01-02 IPP Rev:E

08-01-09

Added Step 2 08-10-15

JLM JLM Verified By:EC

New Manufacturing Method JLM Verified By:EC

Start Date: 5/19/2010

Start Qty: 2.00

Required Date: 5/26/2010

Required Qty: 2.00

D2274

Manufactured

No

170

Each

569.0000

Sp. Radius Block

		Location	Lo	c Qty	Loc Code
		ST010		569	
		54850		4	
		56686		59	
		57714		233	
		57912		273	
Manufactured	No		170	Each	0.0000

Bearpaw, 206

D2438 ---

D2529

Manufactured

No

170

Each

73.0000

Location ST456

Manufactured No Loc Qty

73 73 Each Loc Code

622.0000 /6 8 X m/ L 13/06/11

16x m-h 10/06/11

170

Location ST017

56184

55603

Loc Oty 622

> 22 600

Loc Code

16x m/h 10/06/11

W/O:			WC	RK ORDER CHANG	ES				£ >
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition):	_ QA: N/C (Closed:		Date:	
NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, May 19, 2010 3:30:18 PM

Work Order ID: 58871

Parent Item:

Comments:

D500-572-011

Parent Item Name:

Bearpaw

IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□

IPP Rev:D 07-01-02

IPP Rev:F 08-10-15

IPP Rev:E 08-01-09

Was K10007 Added Step 2

JLM JLM Verified By:EC

New Manufacturing Method JLM Verified By:EC

MS21042L4

Purchased

No

170

Each

2,791.000

Start Date: 5/19/2010

Start Qty: 2.00

<u>Location</u>	Loc Qty
ST139	2
111827	2
ST300	2789
113422	80
114523	1701
114718	1000
9063	8

Loc Code

16x m/k 10/06/11

Wednesday, May 19, 2010 3:30:18 PM

Shop Packet Print

Page 3

Page 3

Required Date: 5/26/2010

Required Qty: 2.00

W/O:			W	ORK ORDER CHA	NGES		——————————————————————————————————————			
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		_							-11	
Part No	:	PAR #:	Fault Cate	egory:	NCI	R: Yes I	No DQA	١:	_ Date: _	
		esolution:								
NCR:			WORK ORD	ER NON-CONFOR	RMANCE	(NCR)	177 (A., J. J. J. P., LAV.		
DATE	STEP	Description of NC	Initial		Section B	Cian 9	Verific		Approval	Approval
		Section A	Chief Eng	Action Descripti Chief Eng	on	Sign & Date	Section	on C	Chief Eng	QC Inspector
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REFERENCE ONLY



32.3 WEIGHT AND BALANCE

Installation	Weight	LAT	ERAL	LONGITUDINAL		
	Weight	Arm	Moment	Arm	Moment	
D500-572-011 Bearpaw Installation	8.5 lb	0.0 in	0.0 lb-kg	130 in	1105 in-lb	
	3.86 kg	0.0 m	0.0 m-kg	3.30 m	12.74 m-kg	
D500-572-021 Narrow Bearpaw Installation	7.5 lb	0.0 in	0.0 lb-kg	130 in	975 in-lb	
	3.41 kg	0.0 m	0.0 m-kg	3.30 m	11.25 m-kg	
D500-572-013 Bearpaw Installation	11.4 lb	0.0 in	0.0 lb-kg	128 in	1459 in-lb	
	5.17 kg	0.0 m	0.0 m-kg	3.25 m	16.80 m-kg	
D600-572-015 Bearpaw Installation	11.4 lb	0.0 in	0.0 lb-kg	122 in	1391 in-lb	
	5.17 kg	0.0 m	0.0 m-kg	3.10 m	16.03 m-kg	

32.4 PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
Х				D500-572-011	BEARPAW INSTALLATION
	Х			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			Х	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
ķ.	4	2	40.00 to	D2995	BEARPAW
	* '		2	D2996	BEARPAW
				, <u>, , , , , , , , , , , , , , , , , , </u>	
4	4	4		D2182B050 ^r	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274 i	RADIUS BLOCK
` 4	4	4	·	D2438 .	CLAMP
			4	D2519	CLAMP
8	. 8	8	8	D2529	WASHER
ъ.,		8	8	AN4-13A	BOLT
. 8	8			AN4-15A 📝	BOLT
8	8	8	8	AN960JD416 /	WASHER
. 8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
1			4	⁻ QS100M24S	CLAMP

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W/O:			WC	RK ORDER CHANG	ES							
DATE	STEP	PR	OCEDURE CHAI	EDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	PAR #: Fault Category:				NCR: Yes No DQA: Date:					
Resolution:			Disposition	QA: N/C C	A: N/C Closed: Date: _							
NCR:		, —	WORK ORDE	ER NON-CONFORMA	NCE (NC	7)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verific	cation	Approval	Approval			
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